

5/29/2018

[Dart Hawkesbury] Job Sheet - David, Logan

SL2500Y-A NV5000-1

4306

SHIP

717

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DART AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

RBEM622V4008101-7
Job Sheet 178247

Part No: RBEM622V4008101-7 Job Qty: 6 ea

Part Name: Support 2

Part Weight: 0 lbs Status: At Planning Priority: Medium

Job Created: 5/29/18 Job Tracking No:

Due Date: 7/9/18 Created By: Logan David

Type: SOLD Description:

Note: DWG RBEM622V4008101 Rev. 3 IPP Rev. A 18.05.18 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup hrs Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
110	Start up Operation	6 Ea	7/9/18	7/9/18	0.00 0.00	Start Up Machining-4		
120	Mori Seiki	6 pcs	7/9/18	7/9/18	0.00 3.00	MORI SL2500Y		
130	QC	6 pcs	7/9/18	7/9/18	0.00 0.00	QC2 Machining-5		
140	Mori Seiki	6 pcs	7/9/18	7/9/18	1.00 1.50	MORI NV5000-1		
150	QC	6 pcs	7/9/18	7/9/18	0.00 0.00	QC2 Machining-5		
160	QC	6 pcs	7/9/18	7/9/18	0.00 0.00	QC8 Machining-5		
200	Powdercoat	6 pcs	7/9/18	7/9/18	0.00 0.60	Powdercoat13		
210	QC	6 pcs	7/9/18	7/9/18	0.00 0.00	QC3		
220	Packaging	6 pcs	7/9/18	7/9/18	0.00 0.00	Packaging 3		
230	QC21-SA	6 Ea	7/9/18	7/9/18	0.00 0.00			

Part Op 120 - 1-Machine as per folio FC 188 FOLIO REV: AA DWG REV: 3 2-Debur

Descriptions: 140 - 1-Machine as per folio FC 188 FOLIO REV: 3 2-Debur

200 - START TIME: 3:15 OVEN TEMPERATURE: 320 FINISH TIME: 3:45 ***See note 1***

220 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.250	303 Round Bar 0.250"	1.5600 ft (.26 ea)	110-Start up Operation	5098 042

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Start up Operation	M303R0.250	2	7	0

Part Specifications

Specifications could not be found.

DART AEROSPACE

Container No: S109410



Part: RBEM622V4008101-7

Job No: 178247

Serial No/Batch: S109410

Revision: 3

Inspector:

Exp Date:

Instructions:

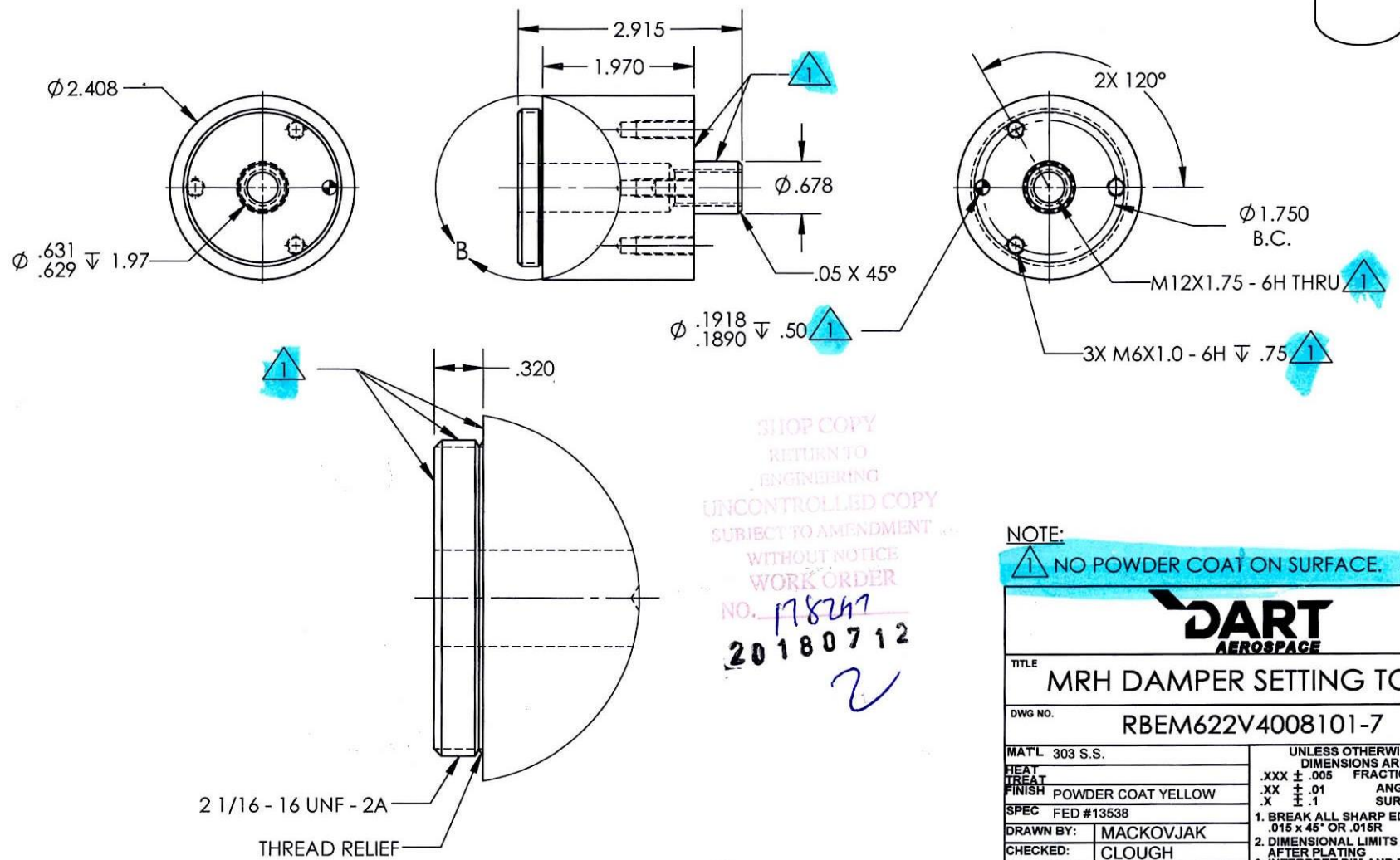
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Plex 5/29/18 9:44 AM dart.logan.david

Date: 09/12/18

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2	16-0173	-7 CH'D MATERIAL WAS A36/1018/1020 HR IS STRESSPROOF, CH'D DIM WAS Ø2.165 IS Ø2.165 +.000/-0.010, ADDED DIM .05 X 45°, CH'D NOTE WAS  IS  ADDED BREAK EDGE NOTE.	10/17/2016	RJC
3	17-0071	-7 REMOVED DIM .190, Ø2.165+.000/-0.010, 60°, Ø2.087; REMOVED NOTE "BREAK EDGE"; CH'D DIM WAS Ø.625 ∇ 1.97 IS Ø.631/.629 ∇ 1.97; ADDED DIM 2 1/16 - 16 UNF - 2A; ADDED NOTE "THREAD RELIEF"; CH'D MAT'L WAS STRESSPROOF IS 303 S.S.; REMOVED FINISH ZINC PLATE SPEC ASTM B633 TYPE 1, SC2.	3/24/2017	SM



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WITHOUT NOTICE
WORK ORDER
NO. 178247
20180712
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NOTE:

 NO POWDER COAT ON SURFACE.

DART AEROSPACE	
TITLE MRH DAMPER SETTING TOOL	
DWG NO. RBEM622V4008101-7	REV 3
MAT'L 303 S.S.	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$.005 FRACTIONS $\pm$ 1/8
FINISH POWDER COAT YELLOW	.XX $\pm$.01 ANGLES $\pm$ 5°
SPEC FED #13538	.X $\pm$.1 SURFACES = 125/
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 X 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 3/3/2016
SHEET 5 OF 11	

DETAIL B
SCALE 1:1

(-7)
SUPPORT 2